



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4885-3

Job Sheet 183308



Part No: D4885-3

Job Qty: 12 ea

Part Name: End Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/15/18

Job Tracking No:

Due Date: 10/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Machining-3		
105	Doosan	12 pcs	10/10/18	10/10/18	0.00	12.00	Doosan		
115	CNC Vertical Machining	12 pcs	10/10/18	10/10/18	0.00	9.00	HAAS5 HAAS5AXIS		
117	QC	12 pcs	10/10/18	10/10/18	0.00	0.00	QC2 Machining-3		
120	QC	12 pcs	10/10/18	10/10/18	0.00	0.00	QC8 Machining-3		
130	Outsource	12 pcs	10/10/18	10/10/18			SKY002-VC		
140	Packaging	12 pcs	10/10/18	10/10/18	0.00	0.00	Packaging2		
150	QC	12 pcs	10/10/18	10/10/18	0.00	0.00	QC5		
160	Packaging	12 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3-2		
170	QC21-SA	12 Ea	10/10/18	10/10/18	0.00	0.00	QC21		

Part Op 105 - Machine blank as per Machinist's turning detail, folio+drawing D4885-3.

Descriptions: 115 - Mill as per folio FB547. Dwg. rev: Folio rev:

130 - ISSUE P/O: 04158 LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417

160 - IDENTIFY AS PER QSI 044 6.1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	4.9200 ft (41 ea)	90-Start up Operation	5120117

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.000	5	9	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART AEROSPACE LTD		Work Order:	183308
Description:		Part Number:	04885-3
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.670	+0.00 -0.01	.6698				
Ø.500	-0.01 +0.06	.501				
Ø.125 x4	-0.001 +0.004	.127				
1.410	+/- .03	1.411				
.500	+/- .01	.499				
.43	+/- .03	.433				
1.45 .030	+/- .01	1.45 .036				
1.45	+/- .03	1.448				
1.21	±.030	1.210	—		Ver M-08	
3.58	±.030	3.584	—		"	
2.025	2.025 ±.005	2.025	—		"	
.063	±.010	.068	—		"	
.28	±.030	.284	—		"	
.360	±.030	.365	—		"	
R.13	±.030	R.125	—		"	
.69	±.030	.690	—		"	
1.83	±.030	1.827	—		"	
R.06	±.030	.063	—		"	
.68	±.030	.680	—		"	
Ø.749	±.006	Ø.7495	—		"	
1.06	±.030	1.057	—		"	
.073	±.010	.076	—		"	

Measured by:	<i>amf</i>	Checked by:	<i>B.F.</i>	QC Inspector:	
Date:	18/10/30	Date:	18-10-30	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S120498



Part: D4885-3

Job No: 183308

Serial No/Batch: S120498

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041518**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041518
PO Date: 10/30/18
Due Date: 11/2/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183308	D4885-3	End Fitting : Various STC's ISSUE P/O LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed	-	11/2/18	12 pcs	0 pcs	12 pcs	\$156.00/pcs	\$1,872.00

12 X OCT 31 2018

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30
9-89

Line Item Note **RUSH NEED ASAP**

Grand Total: \$1,872.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

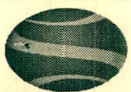
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/30/18 2:09 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38001	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041518 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
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Work Required:

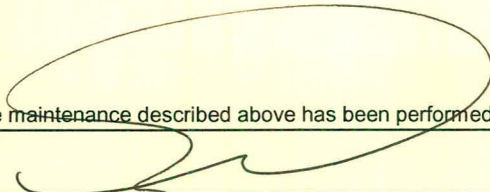
CARRY OUT NDT ON 12 END FITTINGS P/N# D4885-3 , J/S# 183308 AS PER PO041518 ✓

Action Taken:	Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16 ***NO CRACK FOUND*** PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142	OCT 30 2018	 

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

DAS
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9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: OCT 30 2018
Name: RAFIK MELIKIAN		

100-0-0-170

100-0-0-170

100-0-0-170